

S/20

DART AEROSPACE LTD	Work Order:	23234
Description: Support Arm	Part Number:	D3165-1
Dwg: D3165 Rev. A	Qty:	30 32

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller batch: M170291 (M6061T6 B0.500 x 6.00)	JK	05.05.09	30
2	MV	Cut Blank: (17.00" x 5.00") +/- 0.030" x 0.500" thick Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) per (M6061T6B0.500x17.000) Grain along 17.000" 5.00 Batch M17037	JK	05.05.09	22
3	MV	Machine as per Folio FA277 & Dwg D3165-1	JK	05/05/11	32
4	QC2	Inspect parts as they come off the CNC machine	JK	05/05/11	32
5	MV	Deburr & Tumble	JK	05/05/11	32
6A	QC8	Second check inspection	JK	05/05/11	32
6B	MV	Engrave Batch number as per Dwg D3165	JK	05/05/11	32
7	FP	Acid etch and alodine per QSI 005 4.1	JK	05/05/11	32
8	FP	Powder Coat White (4.3.5.1) per QSI 005 4.3	ML	05.05.12	32
9	QC3	Inspect Powder Coat	JK	05/05/11	32
10	ST	Identify and Stock	JK	05/05/11	32
11	AC	Cost / part 31.43	JK	05-05-17	32
12	DC	Close W/O 31.43 Inspect Level 21	JK	05.05.25	32

Rev	Date	Change	Revised By	Approved
A	02.09.18	New issue	KJ	J

RELEASED  
02/10/02 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.05.09	3	-1 part damaged by c-drill, wrong  , operator error	AB 050509	Destroy + Replace	TSCL 05/05/10	AB 05.05.10	AB 050509	AB 050510

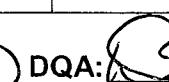
Part No: D3165-1

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No

DQA: 

Date: 05/05/09

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

D3065-5DART AEROSPACE LTD	Work Order:	23234
Description: Support Arm	Part Number:	D3165-1
Inspection Dwg: D3165	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

 First Article  Prototype

Measured by:	<u>E</u>	Audited by:	<u>TS</u>	Prototype Approval:	N/A
Date:	05-05-09	Date:	05/05/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED

04.06.27



COPIED  
ISSUED

DESIGN	DRAWN BY	CP
CHECKED	APPROVED	CP
DATE	02.07.09	TITLE
		SUPPORT ARM

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

REV. A  
SHEET 1 OF 1  
1:3

A	02.07.09	NEW ISSUE
---	----------	-----------

ENGRAVE P/N AND BATCH NUMBER IN THIS AREA AS  
REQUIRED, USING 0.150 HIGH LETTERING WITH A  
MAX DEPTH OF 0.010

Ø 0.257  
(TYP 2 PLACES)

Ø 0.250

Ø 0.250

Ø 0.625  
(TYP)

0.625 (TYP)

4.433

1.250 (TYP)

15.500

R5.0

125°

14.07

8.314

9.95

1.250 (TYP)

15.500

125°

14.07

8.314

9.95

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyMay 09, 2005  
10:58 am

Work Order No : 0023234  
 Project Name : D3165-1  
 Project For : WK520  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3165-1  
 Description : Support Arm  
 Manufactured : Yes  
 Amount Req'd : 30  
 Amount Done : 0  
 Start Date : 05-09-05  
 Est Finish Date : 05-19-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00

Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	0.00	0.00	0.00		
<hr/>					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00